

Date: Tuesday, 19/08/2008 4:03:49 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEAR PLATE
 Job Number : 41424
 Estimate Number : 11232
 P.O. Number :
 This Issue : 19/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2365
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D2365 REV C
 Previous Run : 38331 Project Number : N/A
 Material : C
 Due Date : 05/09/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : JLD 08.8.19
 Comment : Est Rev A Removed from 9 Digit 05-12-05 JLM
 (Est Rev:B Now On Waterjet 08-04-04 JLM
 Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.0049 sf(s)/Unit Total : 0.0592 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Batch: 108279 18 8-8-29

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2365
 Dwg Rev: C
 Prog Rev: C

18 8-8-29

30

2-Deburr if necessary H

08/10/01 30 hm

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

18 8-8-29

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/10/02 countes
130

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

08-10-02 counted
130

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:03:49 PM
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Drawing Name: WEAR PLATE

Job Number: 41424

Part Number: D2365

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/10/02 (1)

7.0

FE832EF

PEM Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 FE832EF PEM Insert

3XM108247
M109011 x 27

Batch not in comp

08/10/07 (x2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2365

08/10/07 (30x)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counted
08/10/07 (x30)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 573d

08/10/08 (x30)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08 (x30)

Job Completion



08/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

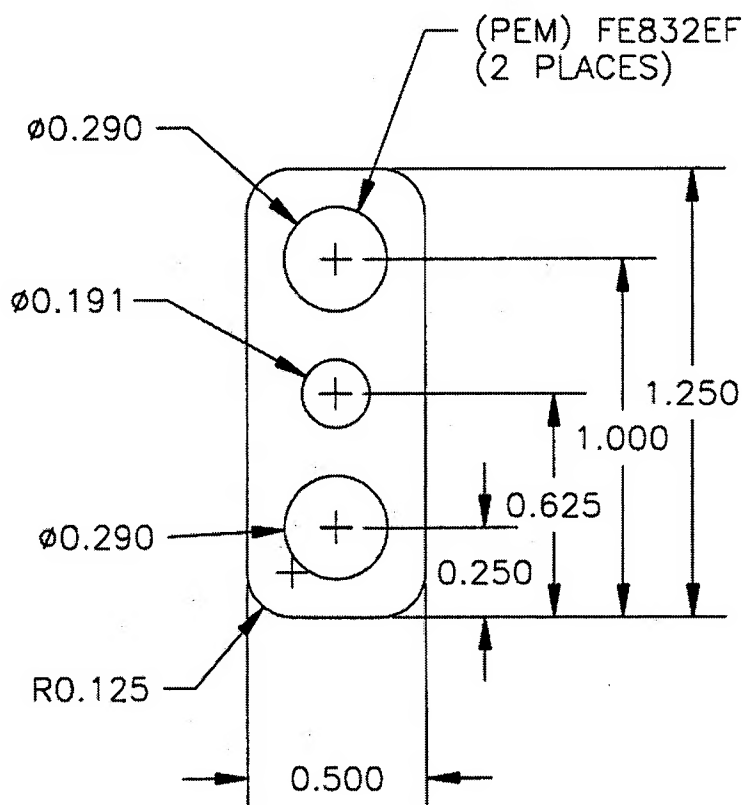
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C
CHECKED BW	APPROVED [Signature]	D2365	SHEET 1 OF 1
DATE 95:01:20	TITLE WEAR PLATE	SCALE 2:1	
C	95:03:06	0.191 WAS 0.197	

RELEASED
17/04/22 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41424

6061-T6 (02-A-250/11) 0.063 THICK } # 00.09.26
ACID ETCH & ALODINE PER QSI 005 4.1-1 } #
INSTALL FE832EF (2 PLS) AFTER ALODINE } # 00.03.07
~~AKS 304/316 SS~~
MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK.
AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES }